

Ship April 22nd

Work Order ID 144571

144571

Page 1

Thursday, April 21, 2016 10:45:02 AM

Item ID: D119-796-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection
 Start Date: 4/21/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/29/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MMF Date: 16-4-21 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D119-796-021	A
IIN-D119-796	E

MCS APR 27 2016

100 Pick Kit 0.00

100

Packaging

Packaging

Memo

Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork

APR 26 2016

DAS
6
8-89

110 0.00

110

HandFinish

Hand Finishing

Memo

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

ASSEMBLE WITH PROSEAL BATCH: M134039

2-INSTALL DECAL D2729-4

DAS
36
9-89

R 16/04/18

144571

Thursday, April 21, 2016 10:45:02 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/21/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/29/2016 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-796-021

Location:

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Picklist Print

Thursday, April 21, 2016 10:45:01 AM

Page 1

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD IPP
REV:B 15.08.25 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-041		Manufactured	No			110	Each	2.0000	2	2			DAS 36 9-89
D119-646-041									**			16/04/27	
Replacement Skidtube with Wearpads, Fits LH or RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					B144262 (IX)
					143598			1					B 143601 (IX)
					143599			1					
D119-796-151		Manufactured	No			110	Each	1.0000	1	1			DAS 36 9-89
D119-796-151									**			16/04/27	
FWD Crosstube Installation with Step (no hardware)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				1					B143551 (IX)
					136817			1					
D119-796-251		Manufactured	No			110	Each	1.0000	1	1			DAS 36 9-89
D119-796-251									**			16/04/27	
AFT Crosstube Installation with Step (no hardware)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				1					B143548 (IX)
					141075			1					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

Picklist Print

Page 2

Thursday, April 21, 2016 10:45:02 AM

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No

110 Each 511.0000 48 48

DAS
6
9-89

D2652

Bushing

**

132 7/2X8

Location

Loc Qty

Loc Code

FG 45
31985 45
ST009 466
141077 159
141609 307

48

APR 26 2016

DAS
36
9-89

D3407-041 Manufactured No

110 Each 1.0000 2 2

D3407-041

Tow Ring

**

16/04/27

B142671 (2x)

Location

Loc Qty

Loc Code

st530 1
142670 1

D3417-5 Manufactured No

110 Each 56.0000 4 4

D3417-5

Washer

**

DAS
8
9-89

Location

Loc Qty

Loc Code

ST035 56
140183 56

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Thursday, April 21, 2016 10:45:02 AM

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

132.0000

2

2

D3456-1

Washer

**

DAS
8

9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

25

141125

25

ST038A

100

141989

50

144158

50

D3672-3

Manufactured No

110

Each

1,381.000

48

48

D3672-3

Washer, Phenolic

**

DAS
8
9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

213

132639

213

ST049

68

~~137234~~ 14

68

ST051A

1000

139583

500

142571

500

APR 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
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Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Page 4

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Work Order ID: 144571

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Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-7

Manufactured No

110

Each

1,154.000

48

48

D3672-7

Washer, Phenolic

**

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

114

137756

114

ST051A

1000

134786

500

142572

500

D3883-1

Manufactured No

110

Each

8.0000

2

2

D3883-1

Saddle, Outboard LH

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST404

8

142275

8

D3883-2

Manufactured No

110

Each

5.0000

2

2

D3883-2

Saddle, Outboard RH

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST404

5

142276

5

D3884-1

Manufactured No

110

Each

8.0000

2

2

D3884-1

Saddle, Inboard LH

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST404

8

142273

8

2

APR 26 2016

Thursday, April 21, 2016 10:45:02 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

D3884-2 Manufactured No

110 Each 5.0000 2 2

D3884-2

Saddle, Inboard RH

**

9-89
0-86

Location

Loc Qty

Loc Code

ST404

5

142274

5

D3886-041 Manufactured No

110 Each 2.0000 4 4

D3886-041

Lug Assembly

**

2

1204 5/2 x 2

9-89
0-86

Location

Loc Qty

Loc Code

ST528

2

136679

2

AN3C46A Purchased No

110 Each 278.0000 8 8

AN3C46A

Bolt

**

2

132381 x 4

9-89
0-86

Location

Loc Qty

Loc Code

FG

10

122843

10

OVER002

210

M133332

70

M133917

70

M134591

70

ST346

58

M132169

24

M132522

34

7

APR 26 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : ☐																																																																									

Picklist Print

Thursday, April 21, 2016 10:45:02 AM

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C50A

Purchased

No

110

Each

133.0000

16

16

AN3C50A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

OVER002

50

M134494

50

ST346

83

M133606

80

M133842

3

15
1

AN4C6A

Purchased

No

110

Each

505.0000

24

24

AN4C6A

Bolt

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

300

m134502

300

ST345

191

m131410

1

m133990

190

24

APR 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 7

Thursday, April 21, 2016 10:45:02 AM

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

1,110.000

24

24

MS21043-3

Nut

**

13238274

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	80
103691	80
FP001	11
m130673	11
GA	385
m133990	385
OVER007	400
m134502	400
ST302	128
m133577	128
ST304	106
m131340	106

20

MS21043-4

Purchased

No

110

Each

917.0000

26

26

MS21043-4

Nut

**

APR 26 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	40
104603	40
GA	103
m132803	103
OVER007	300
m134502	300
ST302	300
m134249	300
ST32	174
m133769	174

26

Thursday, April 21, 2016 10:45:02 AM

Shop Packet Print

Page 7

Picklist Print

Thursday, April 21, 2016 10:45:02 AM

Page 8

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-5	Purchased	No	110	Each	248.0000	8	8	
MS21043-5								**
Nut								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
101418	20	
GA	76	
116548	76	
ST302	152	
m132382	52	
m134502	100	

MS21250-05048	Purchased	No	110	Each	50.0000	8	8	
MS21250-05048								**
Bolt (use MS21250-05-048)								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
over006	50	
m133694	50	

NAS1149C0332R	Purchased	No	110	Each	3,545.000	24	24	
NAS1149C0332R								**
WASHER								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1864	
m132262	4	
m132930	1004	
m134063	728	
m134073	128	
GA	225	
m133284	225	
ST266	1456	
m134474	456	
m134574	1000	

APR 26 2016

Thursday, April 21, 2016 10:45:02 AM

Shop Packet Print

Page 8

Picklist Print

Page 9

Thursday, April 21, 2016 10:45:02 AM

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

110

Each

1,167.000

48

48

NAS1149C0432R

WASHER

**

DAS
6

Location

Loc Qty

Loc Code

GA

444

m125807

428

m133790

16

ST266

723

m134073

723

78

NAS1149C0532R

Purchased

No

110

Each

273.0000

16

16

NAS1149C0532R

WASHER

**

APR 26 2016

DAS
6
98%

Location

Loc Qty

Loc Code

GA

60

116513

60

ST266

213

m133031

177

m134181

36

16

139x89x35crate

Purchased

No

110

Each

2.0000

1

1

139x89x35crate

Agusta Crate

**

MP
16-4-29

Thursday, April 21, 2016 10:45:02 AM

Shop Packet Print

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Picklist Print

Page 10

Thursday, April 21, 2016 10:45:02 AM

Work Order ID: 144571

144571

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 4/21/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-28

Purchased

No

Each

72.0000

2

MS21920-28

**

Clamp

Location

Loc Qty

Loc Code

FG

1

105884

1

LG051

1

M132169

1

LG057

70

M134130

2

M134514

30

M134590

38

DAS
6
9-89
APR 26 2016

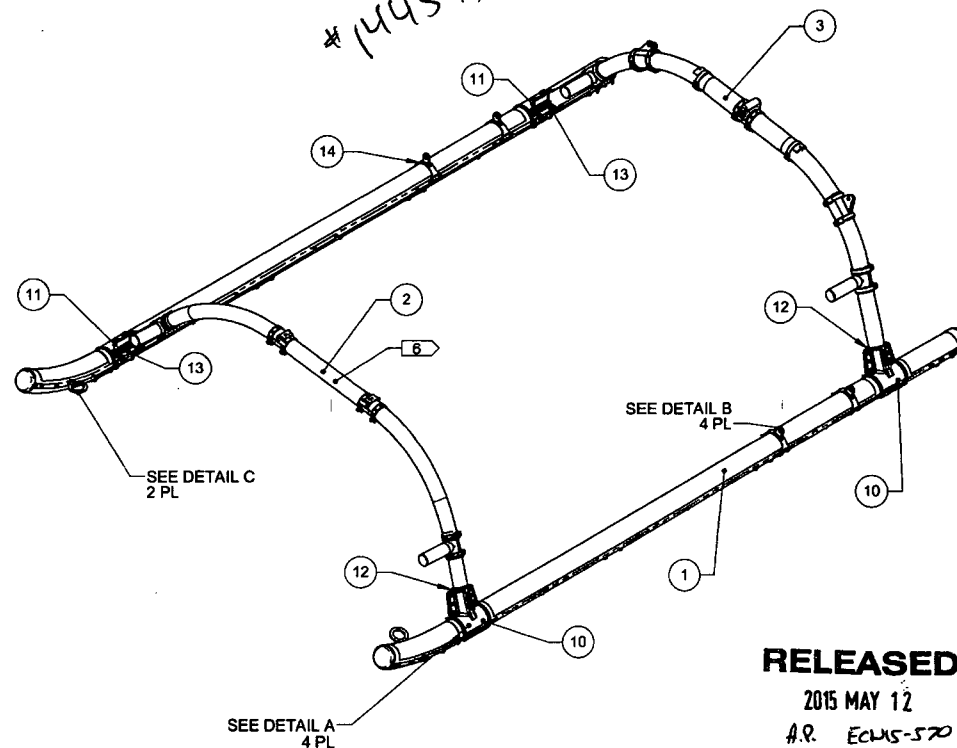
2

Thursday, April 21, 2016 10:45:02 AM

Shop Packet Print

Page 10

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-646-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C6A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	26	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



RELEASED

2015 MAY 12

A.R. ECMS-570

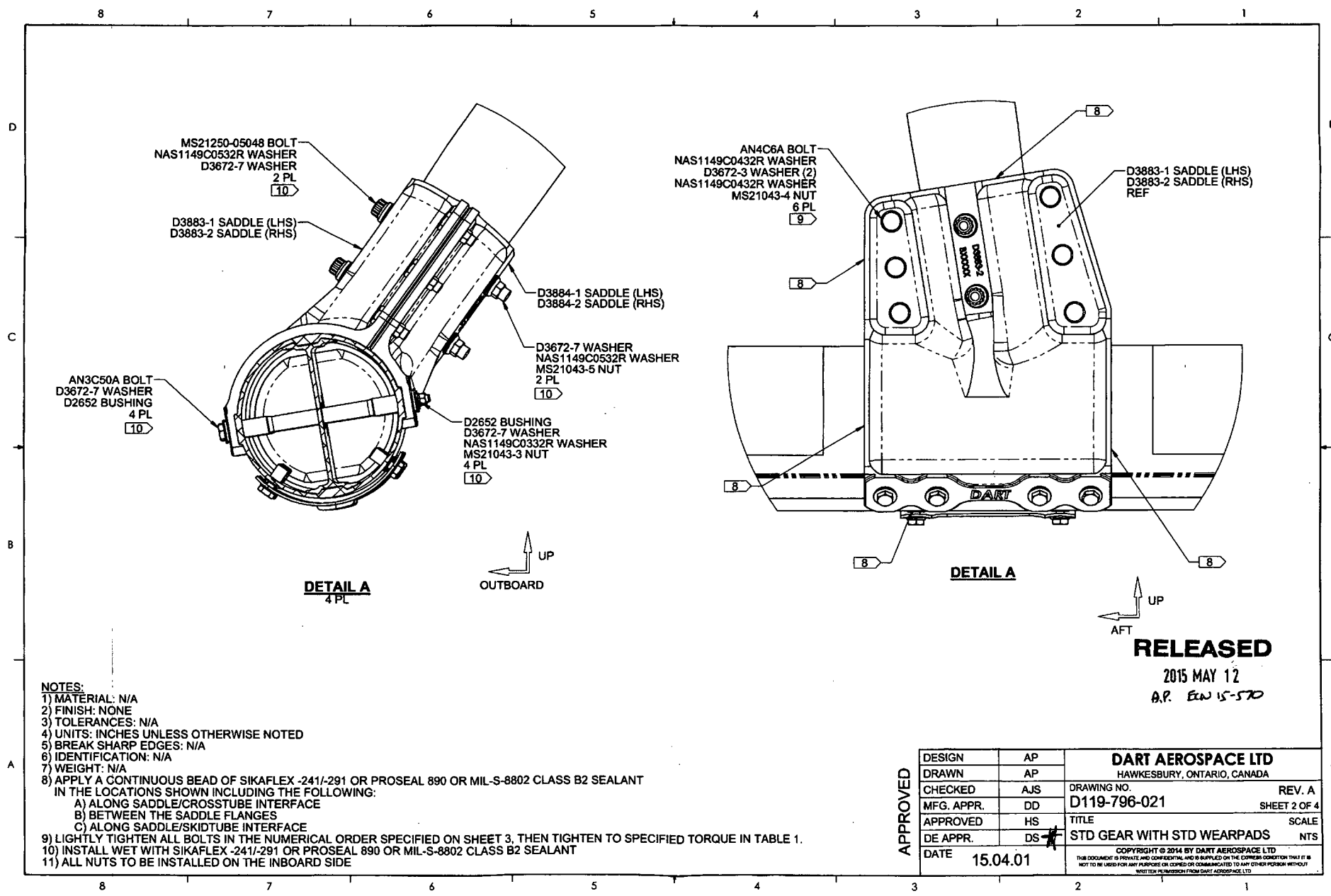
D119-796-021 STD GEAR WITH STD WEARPADS

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 122.7 LBS

A		NEW ISSUE		AP	15.04.01
REV.	DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE LTD			
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA			
CHECKED	AJS	DRAWING NO.	REV. A		
MFG. APPR.	DD	D119-796-021	SHEET 1 OF 4		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS		
DATE	15.04.01				

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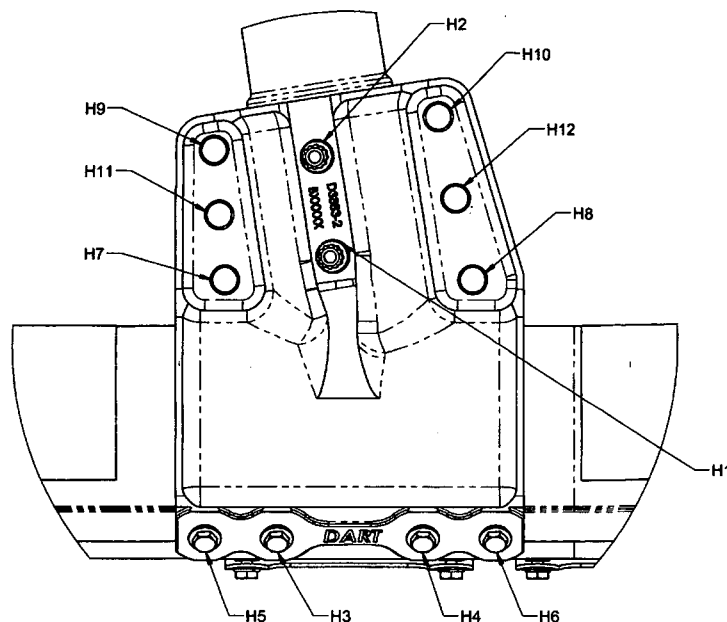


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

RELEASED

2015 MAY 12

A.P. EW15-570

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